

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026133**Date Inspected:** 26-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:** **Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:** **Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:** **Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:** **Yes No N/A****Delayed / Cancelled:** **Yes No N/A****Bridge No:** 34-0006**Component:** OBG 13AW and 13BW**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A. DeArmond was present during the time noted above and conducted observations relative to the work being performed.

ZHENHUA SHIP #19

This QA Inspector witnessed the final bolt tension verification on lifts 13AW/13BW connecting 14~29 and 22~25 U-Rib-to-U-Rib splice, located between PP 120~120.5. This QA Inspector verified the bolt tension on a random basis and the results appeared to be in general compliance. The Inspection was performed against Notification No. 00712; item No. 2 dated July 26, 2011. The following bolt assemblages were utilized:

PP120~120.5

M22 x 65 RC Lot # DHGM220131 and the final torque value established was 380 N-m.

The Manual Torque wrench used was Serial No. XO2-114.

This QA Inspector witnessed the final bolt tension verification on lifts 13AW/13BW connecting U-Rib-to-U-Rib splice, located between PP 120~120.5. This QA Inspector verified the bolt tension on a random basis and the results appeared to be in general compliance. The Inspection was performed against Notification No. 00712; item No. 2 dated July 26, 2011. The following bolt assemblages were utilized:

PP120~120.5

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M22 x 85 RC Lot # DHGM220121 and the final torque value established was 393 N-m.

M22 x 65 RC Lot # DHGM220131 and the final torque value established was 380 N-m.

M22 x 70 RC Lot # DHGM220137 and the final torque value established was 400 N-m.

The Manual Torque wrench used was Serial No. XO2-114.

This QA Inspector witnessed the final bolt tension verification on lifts 13AW/13BW connecting U-Rib-to-U-Rib splice, located between PP 120~120.5. This QA Inspector verified the bolt tension on a random basis and the results appeared to be in general compliance. The Inspection was performed against Notification No. 00712; item No. 1 and 2 dated July 26, 2011. The following bolt assemblages were utilized:

PP120~120.5

M22 x 80 RC Lot # DHGM220140 and the final torque value established was 380 N-m.

M22 x 65 RC Lot # DHGM220131 and the final torque value established was 380 N-m.

The Manual Torque wrench used was Serial No. XO2-114.

This QA Inspector witnessed the final bolt tension verification on lifts 13BW connecting U-Rib-to-U-Rib splice, located between PP 121~121.5. This QA Inspector verified the bolt tension on a random basis and the results appeared to be in general compliance. The Inspection was performed against Notification No. 00712; item No. 1 dated July 26, 2011. The following bolt assemblages were utilized:

PP121~121.5

M22 x 65 RC Lot # DHGM220131 and the final torque value established was 380 N-m.

The Manual Torque wrench used was Serial No. XO2-114.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As mentioned above between QA and QC concerning this project

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150000422372, who represents the Office of Structural Materials for your project.

Inspected By:	DeArmond,Robert	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
